

Date: Monday, 2/19/2007 8:08:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 30757				
Estimate Number	: 12712				
P.O. Number	: N/A		Part Number	: D35371 Rev H 01+ Drawing Number : D3537 UNDER REVIEW 07-02-19	
This Issue	: 2/19/2007 S.O. No. : N/A		Project Number	: N/A	
Prsht Rev.	: NC		Drawing Revision	: U/R	
First Issue	: N/A		Material	: N/A	
Previous Run	: N/A		Due Date	: 2/26/2007 Qty: 72 Um: Each	
Written By					
Checked & Approved By					
Comment	: Est Rev:A New Issue 07-02-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 5.6700 sf(s) M304S16GA .063" 304 SS SHEET 6.0640 Batch: M101873	ml 07/03/07 72
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: A Prog Rev: A	ml 07/03/08 72 07/03/09 72
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		ml 07/03/08	72
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		ml 07/03/08 72	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		ml 07/03/08 72	
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	SB 07/03/14 72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-1 PAR #: N/A Fault Category: Pod/Machined Parts NCR: Yes, No DQA: PD Date: 07/03/20
 QA: N/C Closed: AS Date: 07/03/20

NCR: <u>30757</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		6 scrap, program was wrong.	<u>AS</u>	Scrap + Replace	<u>M</u> <u>07/03/08</u>	<u>AS</u> <u>07/03/08</u>	<u>AS</u> <u>07/03/08</u>	<u>AS</u> <u>07/03/08</u>
<u>07/03/08</u>	2.0	5 were scrap 3 due to program adjustment, and 2 operator error	<u>AS</u>	Scrap + Replace	<u>M</u> <u>07/03/08</u>	<u>M</u> <u>07/03/08</u>	<u>M</u> <u>Scrap</u>	<u>M</u> <u>07/03/08</u>

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:08:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 30757

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
1 AR560 Hardcoat M102755

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FC 07/03/19 (72)

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mo 07/03/19 (72)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo 07/03/19 (72)

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.d 07/03/19

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Le 7/3/19 (72)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 505

(8)

12.0 QC21

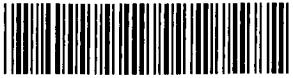
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Mo 07/03/20 (72)

Job Completion



u 07/03/19

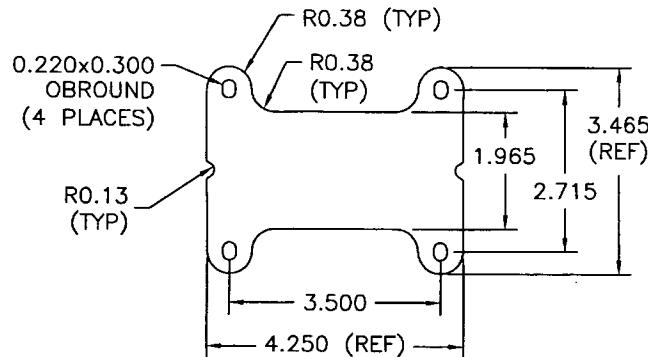
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

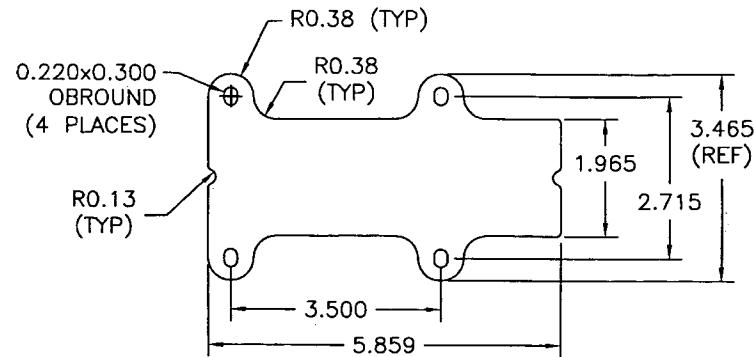
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

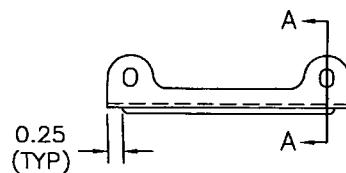
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

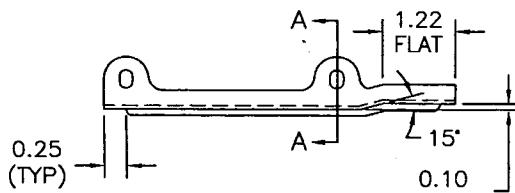


D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)

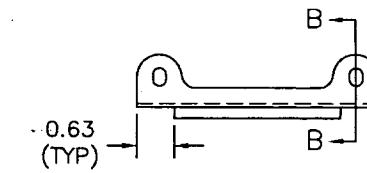


RELEASED
07.02.12

D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



NOTES

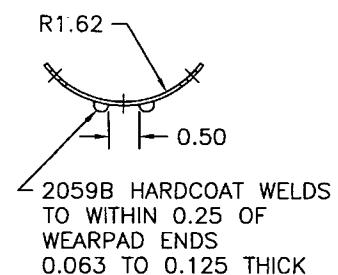
- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 30757
STOP COPY
RETURN TO ENGINEERING
DRAFTSPECS

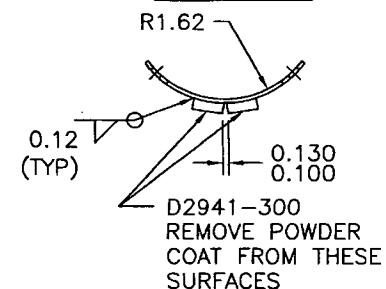
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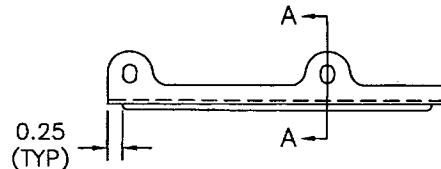
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HANCOCK, VA
CB	CB	
CHECKED PH	APPROVED	DRAWING NO. D3537
DATE 06.11.06	TITLE WEARPAD	REV. A SHEET 1 OF 1 SCALE 1:2

DART AEROSPACE LTD	Work Order:	30751
Description: Wear pad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>M</u>	Prototype Approval:	
Date:	07/03/07	Date:	07/03/08	Date:	

Rev	Date	Change	Revised by	Approved by
A		New Issue	KJ/JLM	